

Date: Friday, 18/07/2008 10:50:29 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT
Job Number :	40616		
Estimate Number :	10203		
P.O. Number :		Part Number :	D21995
This Issue :	18/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2199 REV. E1
First Issue :	1/1	Project Number :	N/A
Previous Run :		Drawing Revision :	E1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/08/2008
Written By :		Qty:	5
Checked & Approved By :	JUL 08.7.18	Um:	Each
Comment :	Est A 02.06.10 New Issue NG/RF		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0750W049

304 RD Tube .750 x .049W



Comment: Qty.: 2.0037 f(s)/Unit Total: 10.0186 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M108498

SR 08/07/21

(5)

2.0

BRAKE NC

NC BRAKE



Comment: BRAKE NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

SR 08/07/21

(5)

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

08/07/28 (5)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/28 (5)

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
 400°F
 2:30

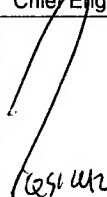
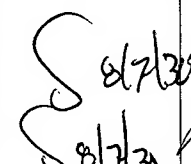
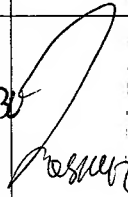


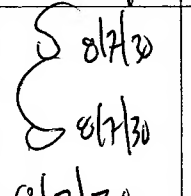
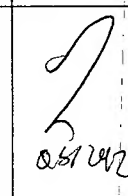
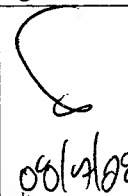
M-L 08/07/29 (3x)
 M-L 08/07/28

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2199-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>40614</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/28	A	Duffing Powder contamination it was found that 3 parts have markings from mark Parts not been cleaned		Scuff with 320 grit sand paper on areas that have markings shown <u>Qty 13</u>	M-11 08/07/28			
				Wash with acetone	M-11 08/07/28			
		R.C. parts were not cleaned enough.		Re Powder as per QS2006	M-11 08/07/29			
				Re inspect as ac3	FL 08/07/29			
						8/7/30		

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 10:50:29 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40616

Part Number: D21995

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 272

8/7/29

SV

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30

Job Completion



MF 08-07-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

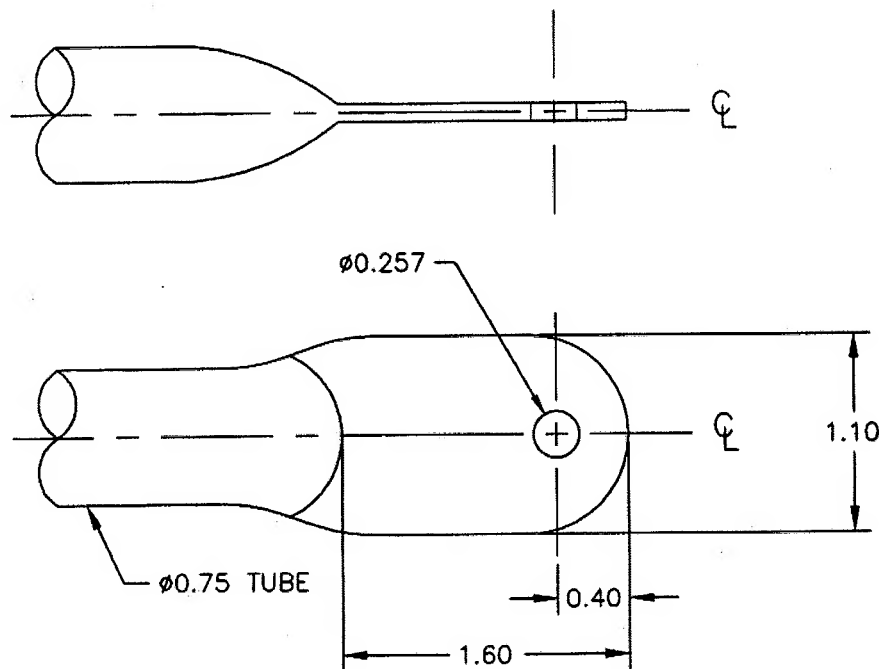
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED mg	APPROVED [Signature]	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/09/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40616

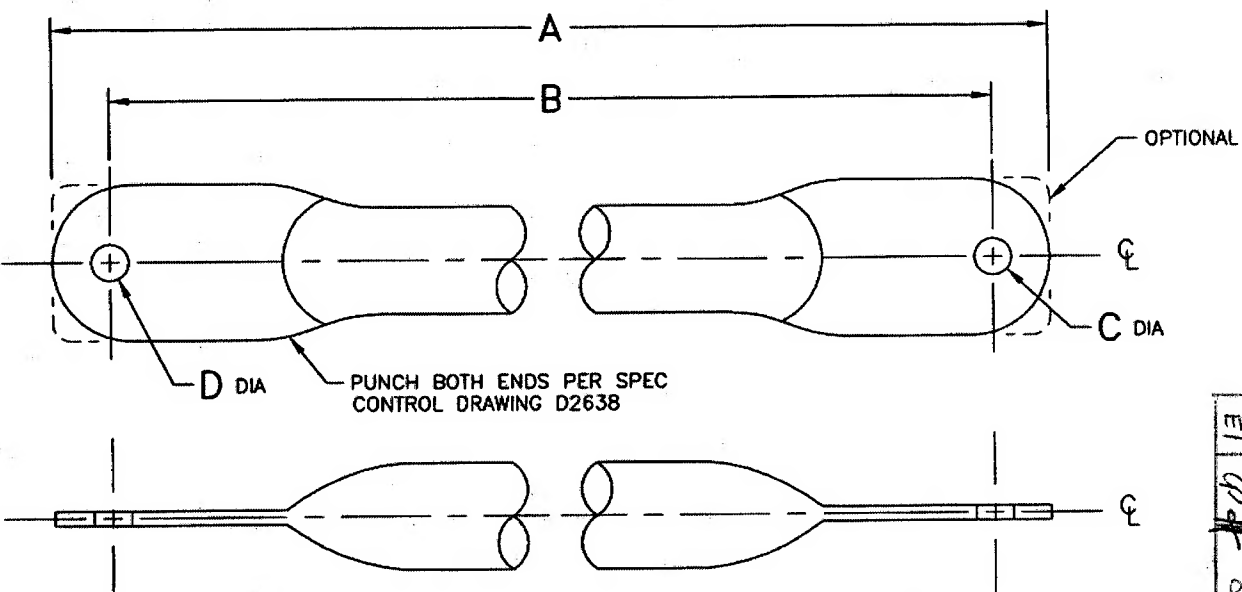
DART



RELEASED
48.05.05 EE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	02.03.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

BBBCCCE

00.10.13
IP 00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT. WHITE (4.3.5.2) PER DART Q51 005 4.3/E1

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